

Ship 08/03

# Work Order ID 56578

March 1, 2010 2:45:25 PM



Page 1

Item ID: D3713-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Assembly

Start Date: 3/01/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

✓

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3713

Rev B

100



Large Fab

Large Fab

Memo

0.00

0.00

1- drill holes in both D3715-1 as per dwg D3715 2- deburr 3- assemble as per dwg D3713 and weld as per QSI004

110



Large Fab

Large Fab

Memo

0.00

0.00

1- cut mesh as per dwg D3743 2- weld mesh as per dwg D3713

120



Large Fab

Large Fab

Memo

0.00

0.00

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. S. 10-03-08

SM 10/03/08

1x

SM 10/03/08

1x

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Work Order ID 56578

March 1, 2010 2:45:25 PM



Page 2

Item ID: D3713-042

Accept



Setup Start



Revision ID:

Item Name: Lid Assembly

Stop



Start Date: 3/01/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Quality Control

Gpc 10-03-08

140

Black Sandtex(Ref:4.3,5.7) per QSI005 4.3

0.00

⇒ M 10/03/09



Powdercoat

Powder Coating

Memo

0.00

START TIME: 7:30 AM OVEN TEMPERATURE:  
FINISH TIME: 3:20 PM

(X) ✓

150

QC3- Inspect Part Finish

0.00

BL 10-3-9



QC

Quality Control

Memo

0.00

① ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 56578**

March 1, 2010 2:45:26 PM



Page 4

Item ID: D3713-042

Revision ID:

Item Name: Lid Assembly

Start Date: 3/01/10 Start Qty: 1.00



Required Date: 3/08/10 Req'd Qty: 1.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

190



QC

Quality Control

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*Jas.19*  
CL1013119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 1, 2010 2:45:23 PM

Page 1 *13*

Work Order ID: 56578



Parent Item: D3713-042



Parent Item Name: Lid Assembly

Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC  
IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:

Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-1		Manufactured				100	Each	33.0000	2.0000			



Spacer Bushing

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	33	
52832	13	
54658	20	

*2x 10/03/01*

D2329



Manufactured

No

110	Each	12.0000	1.0000
-----	------	---------	--------



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	12	
35686	2	
40488	10	

*1x 10/03/01*

Label Plate

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 1, 2010 2:45:23 PM

Page 2 /3

Work Order ID: 56578



Parent Item: D3713-042



Parent Item Name: Lid Assembly

Start Date: 3/01/10

Required Date: 3/08/10

Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC  
IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581 		Manufactured	No			100	Each	47.0000	2.0000			

Mounting Bracket

## Warehouse

### Location

Main Warehouse

ST	5
46086	2
48428	1
51120	2

Main Warehouse

WA	42
50872	1
51745	2
55918	39

D3749-1



Manufactured

No 100 Each 12.0000 3.0000



Hinge Half

## Warehouse

### Location

Main Warehouse

ST	12
38826	12

2x SM 10/03/01

3x SM 10/03/01

March 1, 2010 2:45:23 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

March 1, 2010 2:45:23 PM

Page 3 /3

Work Order ID: 56578



Parent Item: D3713-042



Parent Item Name: Lid Assembly

Start Date: 3/01/10

Required Date: 3/08/10

Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC  
IPP Rev:B change to revB cen 1145 08-03-19 DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	873.8291	17.8947			

Expanded Metal Flat SS

SAD 10-03-02

## Warehouse

### Location

Main Warehouse

MAT	873.8291065	
111956	0.000017	
112147	9.4736E-06	
112949	19.84438	
113205	0.0093	
113497	0.1449	
113555	667.7873	
113904	186.0432	

### Loc Qty

### Loc Code

17.8947

M304TS0.750W.065

Purchased

No

100 f 221.2637 32.6547



304 SQ Tube .75x.75x.065W

SAD 10-03-02

## Warehouse

### Location

Main Warehouse

MAT	221.2636712	
113082	0.00419	
113245	0.00038421	
113683	0.30855	
113836	5.161147	
113956	215.7894	

### Loc Qty

### Loc Code

4.161147  
28.4756

Main Warehouse

WA	0.0000047	
112398	0.0000047	

March 1, 2010 2:45:24 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

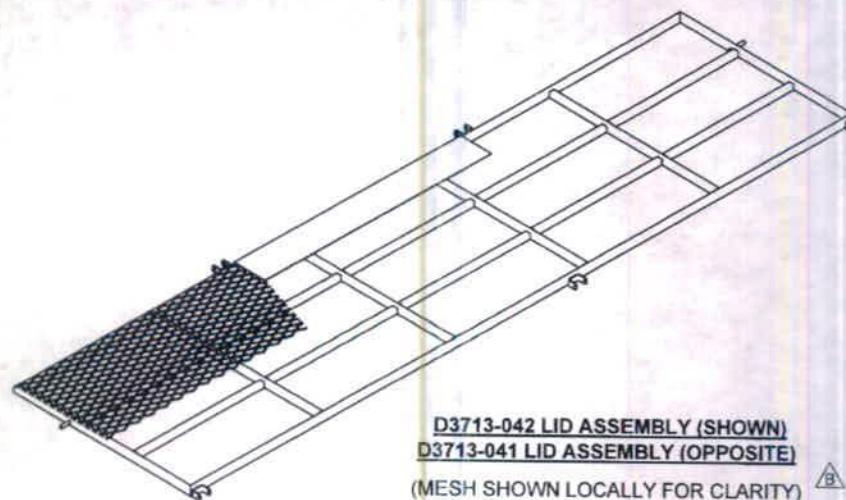
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
X		D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF



D3713-042 LID ASSEMBLY (SHOWN)  
 D3713-041 LID ASSEMBLY (OPPOSITE)  
 (MESH SHOWN LOCALLY FOR CLARITY)

W1056578  
 1108-33711D

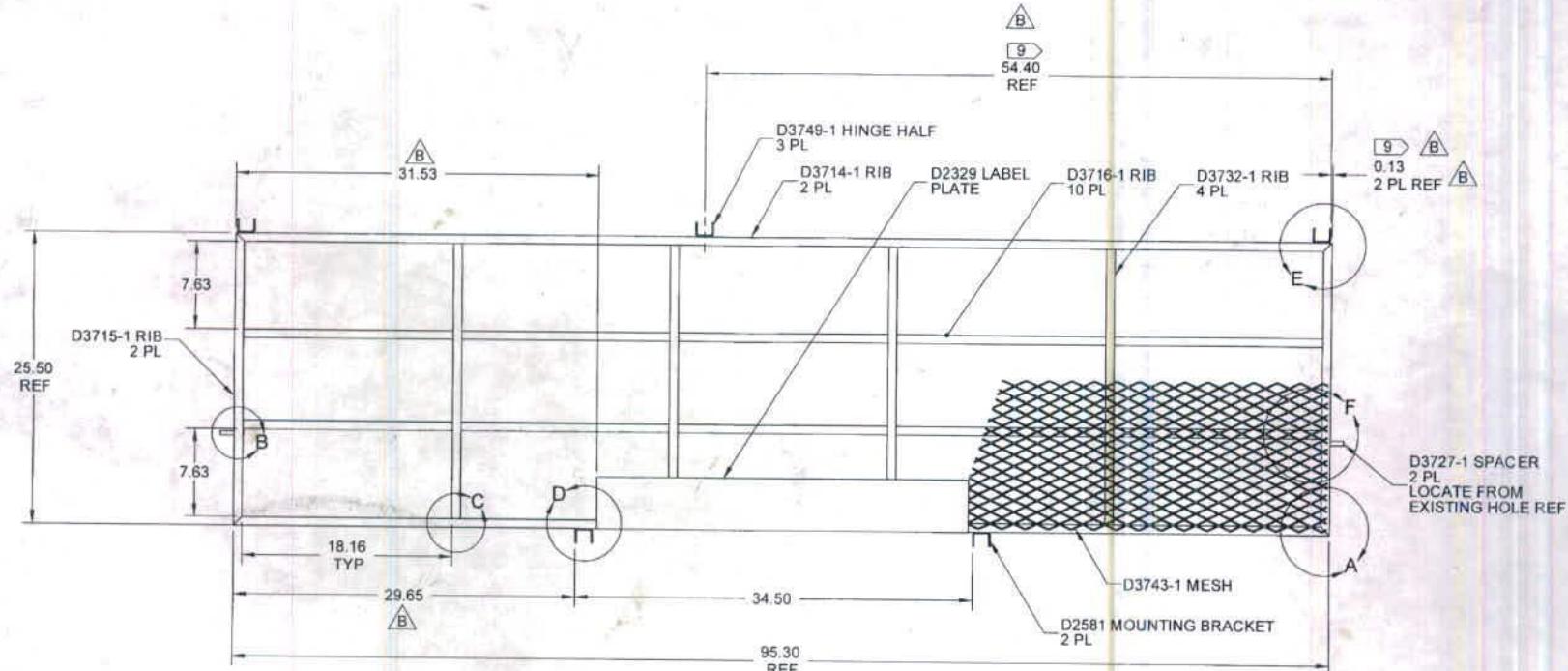
## NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY /B/

8 7 6 5 4 3 2 1

B	SHEET 1-042 WAS -041; ADDED CORRECT -041 ASSEMBLY. NOTE 9 ADDED ZONE D2 TO C2 LID ASSEMBLY. WAS D3713-041. WEIGHT WAS 36 lb. SHOWN 2 ZONE B5 LID ASSEMBLY WAS D3713-041. ZONE D6 31.53 DIM WAS 31.64. ZONE D3 54.40 DIM NOW REF ZONE D2 0.13 REF DIM ADDED ZONE B6 29.85 DIM WAS 29.77. ZONE D3 & D2 FLAG NOTE 9 ADDED.		
A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3713	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LID ASSEMBLY	NTS
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D3713-042 LID ASSEMBLY (SHOWN) **B**  
D3713-041 LID ASSEMBLY (OPPOSITE)  
(MESH SHOWN LOCALLY FOR CLARITY)

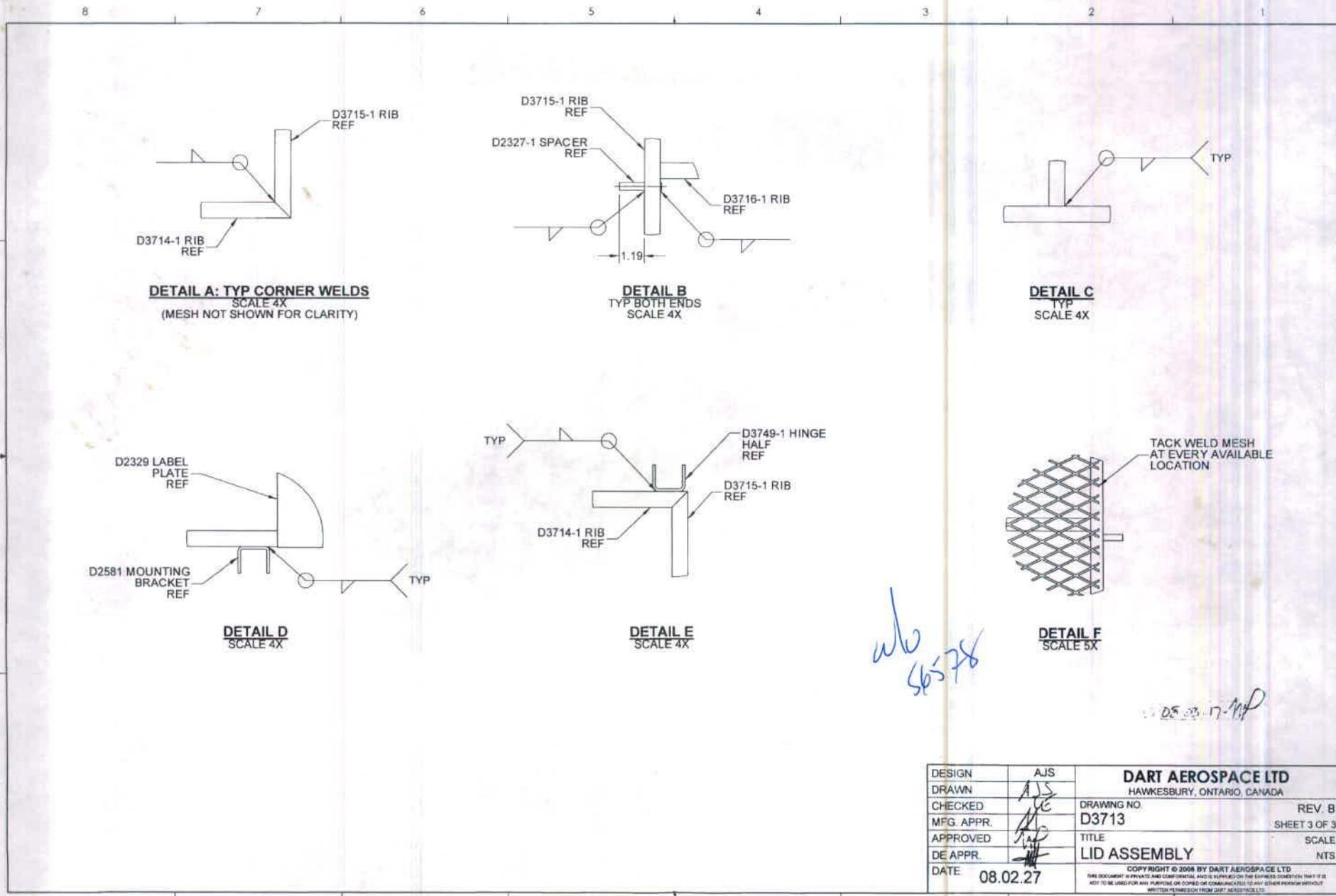
W0  
50578

10/07/17 MD

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	ME	DRAWING NO.
MFG. APPR.	AD	REV. B
APPROVED	AD	D3713
DE APPR.	AD	SHEET 2 OF 3
DATE	08.02.27	TITLE
		LID ASSEMBLY
		NTS

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DRAWN	155	HAWKESBURY, ONTARIO, CANADA
CHECKED	MC	REV. B
MFG. APPR.		DRAWING NO. D3713 SHEET 3 OF 3
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